

ASAP 23/01

Dart Aerospace Ltd.

Date: Friday, 16/01/2009 12:33:44 PM
User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : SLIDING DOOR BRACKET
Job Number : 44875
Estimate Number : 13643
P.O. Number :
This Issue : 16/01/2009 S.O. No. :
Prsht Rev. : NC Part Number : D36753
First Issue : / / Type : SMALL /MED FAB Drawing Number : D3675 REV B
Previous Run : 43441 Drawing Revision : B
Material :
Due Date : 23/01/2009 Qty: 30 Um: Each
Written By :
Checked & Approved By :
Comment : Est Rev:A new issue 08-11.06 EC verified by:DD

Additional Product

Job Number:



SCRAP

Seq. #: Machine Or Operation: Description :

1.0 M304S20GA 304/316 .040 Sheet



Comment: Qty.: 0.1271 sf(s)/Unit Total: 3.8115 sf(s)
304 stainless steel 0.032" Sheet
Batch: 109057 IB 9-1-18

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET
1-Cut as per Dwg D3675
Dwg Rev: B
Prog Rev: B

IB 9-1-18

(33)

2-Deburr if necessary IB 9-1-18

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

S 02/01/19 counter (33)

5.0 BRAKE NC NC BRAKE


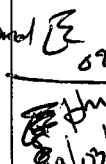




Comment: NC BRAKE
Form as per Dwg D3675

S 09/01/20 (33)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3675-3 PAR #: N/A Fault Category: Prod Eng. Coordinator NCR: Yes No DQA: D Date: 09/03/20
 Resolution: Documentation revised Disposition: Scrap QA: N/C Closed: D Date: 09/03/20

NCR: <u>44875</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
09.03.13	2.0	Parts were made with 0.032" material instead of 0.040"; and measure 0.028" → 0.030" R.C. Incorrect mat'l size on 1.0.		update IPP. seq. 1.0 to state 0.040" material instead of 0.032" Scrap & destroy Qty 33 No replace.	 09.03.13 SB 09/03/13			

NOTE: Date & initial all entries

Date: Friday, 16/01/2009 12:33:44 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SLIDING DOOR BRACKET

Job Number: 44875

Part Number: D36753



Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



counters

Comment: INSPECT WORK TO CURRENT STEP

S09/01/21 (x33)

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

START TIME:

7:30am

OVEN TEMPERATURE:

320°F

FINISH TIME:

8:00am

M109648

SCVAP

91 09-01-23

(x33)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

F2 09/01/23

(33)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

88 PPP 4298

AS

09/01/23 (x33)

(PTC)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF

09-03-18

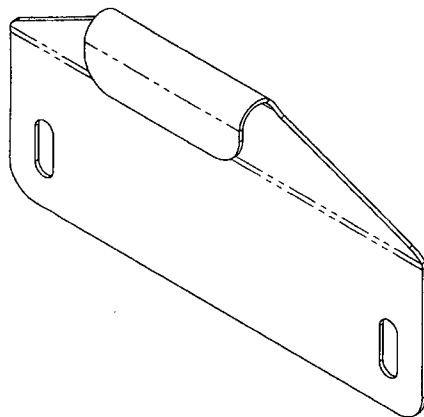
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

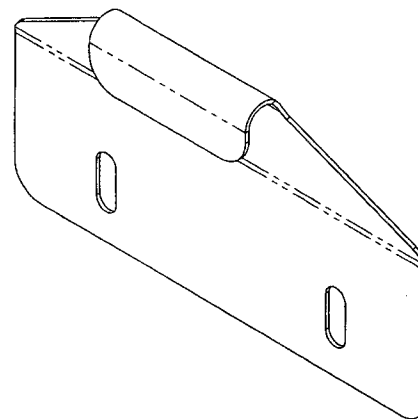
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D3675-1 SLIDING DOOR BRACKET



**D3675-3 SLIDING DOOR BRACKET
(HINGE PANEL MOD)**

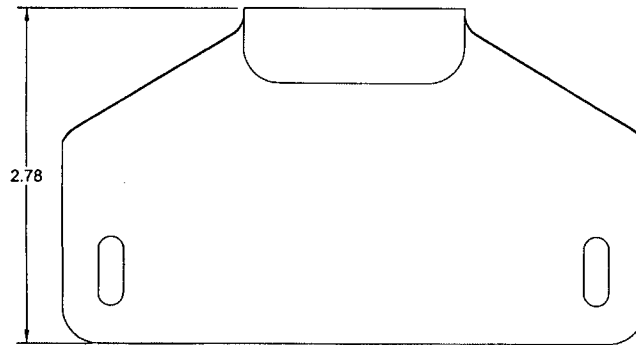
W/044875

RELEASED
08.11.10

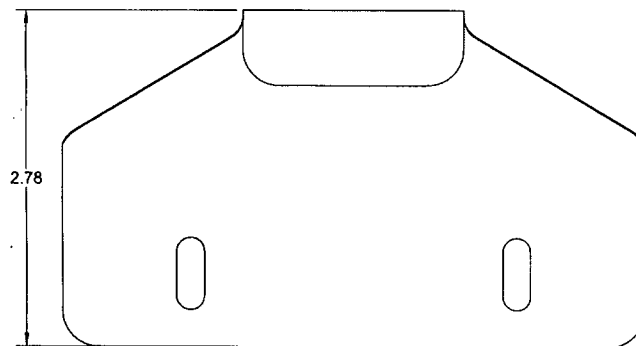
NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 0.040 THICK
PER MIL-S-5059 (ANNEALED)
REF. DART SPEC M304S
- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3675-X" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.15 lbs
- 8) THE D3675-1 SLIDING DOOR BRACKET IS A DERIVATIVE OF THE D3199-1 BRACKET.

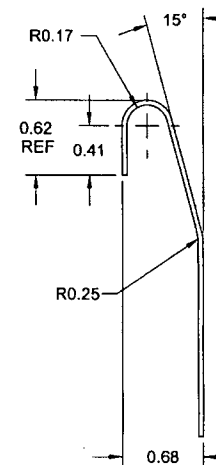
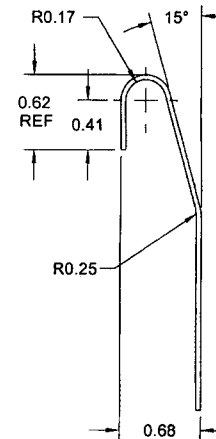
B	ADD -3 FOR HINGE PANEL MOD.	AJS	08.11.03
A	NEW ISSUE	AJS	08.03.27
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>[Signature]</i>	D3675	SHEET 1 OF 3
APPROVED	<i>[Signature]</i>	TITLE	SLIDING DOOR BRACKET SCALE
DE APPR.	<i>[Signature]</i>	(COMPOSITE DOOR)	NTS
DATE	08.11.03	<small>COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	



D3675-1 SLIDING DOOR BRACKET
(MAKE FROM D3675-1F)



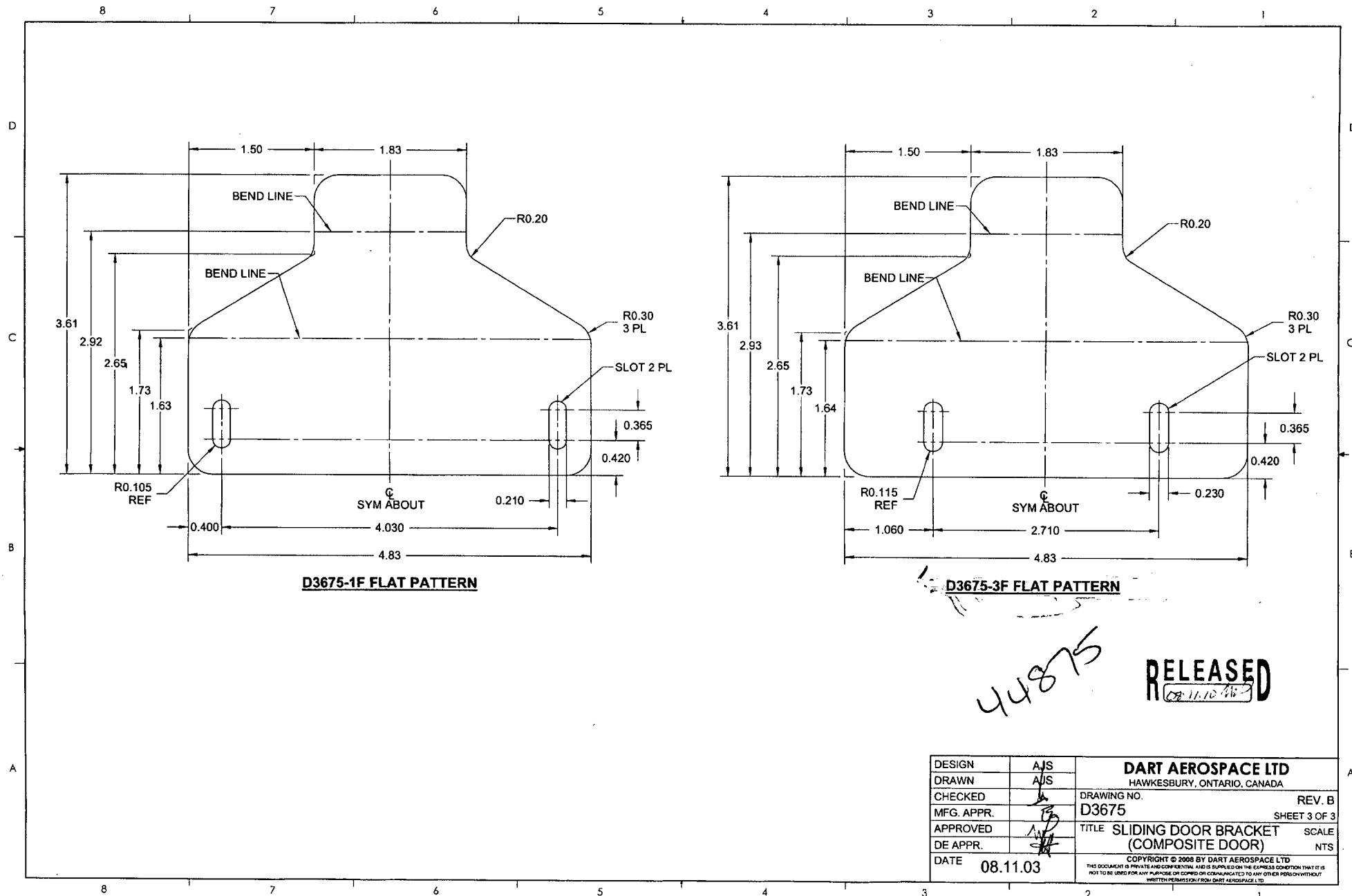
D3675-3 SLIDING DOOR BRACKET
(MAKE FROM D3675-3F)
(HINGE PANEL MOD)



44875

RELEASED
08.11.14

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3675	SHEET 2 OF 3
APPROVED		TITLE	SLIDING DOOR BRACKET
DE APPR.		(COMPOSITE DOOR)	SCALE
DATE	08.11.03		NTS
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FIRST ARTICLE INSPECTION CHECKLIST

<input checked="" type="checkbox"/>	First Article	<input checked="" type="checkbox"/>	Prototype
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Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

L Lacelle

From: L Lacelle [llacelle@dartaero.com]
Sent: January 23, 2009 3:25 PM
To: 'Bill Beckett'
Cc: 'Brigitte Golden'; 'sbedford@dartaero.com'; 'Jason Murdoch'
Subject: AMOD OE 6482

Well, since this order (for this last item) has been a disaster since it started last Friday, it decided to continue. Now, I had the D3202-5's made, painted and ready to add into the kits so it could ship Monday morning, but it will NOT be leaving Monday...the comment on the w/o (estimate too) D3675-3, was wrong, so parts were made to .032 mat'l instead of .040 for the first batch (the second batch was caught on inspection). I was closing the sub component w/o's for this part D3675-3 when I noticed it, and informed Jason. So....we will have to make a 3rd batch of these on Monday, and if we can get thru another miracle of pulling parts out of my ass, we will have them ready to ship Tuesday morning.
Have a great wknd

Thank You,
Linda Lacelle
Production Manager
Dart Aerospace Ltd

13/03/2009